

--21. A synthetic wood-like product having an external foam skin and a foam core, and being of low density, stable dimension, wood-like surface quality, good flammability resistance and outdoor weather durability, made by the method that comprises:

- B<sup>1</sup>
- A.) forming a mixture containing:
    - (a) about 70 to about 100 parts by weight of vinyl chloride resin;
    - (b) about 10 to about 100 parts by weight of a natural cellulosic product;
    - (c) about 0.5 to about 10 parts by weight of vinyl chloride resin foaming agent;
  - B.) mixing the aforesaid mixture in a hot mixer with frictionally induced heating to temperatures of about 80 degrees Celsius up to about 140 degrees Celsius and below the fusion temperature of polyvinyl chloride;
  - C.) subsequently mixing the mixture from said hot mixer in a cold mixer while cooling said mixture to a temperature of about 25 degrees Celsius to about 60 degrees Celsius;

- D.) plastifying and extruding the mixture through a plastifying and extruding means; and,
- E.) slowly cooling extruded product to create a synthetic wood-like product having an external foam skin and a foam core, wherein said cooling is performed in a roller system of a plurality of contra-rotating rollers, said synthetic wood-like product having a surface embossed texture and having a Shore Hardness of at least about 50 D-scale, as measured according to ASTM 2240.

- B<sup>1</sup>
- 22. The synthetic wood-like product of claim 21 wherein said step A.) mixture further includes:
    - (d) about 0.1 to about 100 parts by weight of additives selected from the group consisting of heat stabilizers, processing aids, colorants, lubricants, fillers, flame retardants, ultraviolet light inhibitors, and mixtures thereof.
  - 23. The synthetic wood-like product of claim 21 wherein said plastifying and extruding steps are performed in an extruder.
  - 24. The synthetic wood-like product of claim 21 wherein said mixing step in a hot mixer is performed to a temperature in

the range of about 80 degrees Celsius to about 140 degrees Celsius.

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25. The method of claim 21 wherein said cooling is further performed on a plurality of support rollers after said plurality of contra-rollers.—